

Date: Monday, 3/26/2007 3:04:42 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B UTILITY BASKET		
Job Number	: 31455				
Estimate Number	: 11282				
P.O. Number	: N/A	Part Number	: D206540013	As per Discussion	
This Issue	: 3/26/2007 S.O. No. : N/A	Drawing Number	: D206-540 REV I	with BILL B., TECH.	
Prsht Rev.	: NC	Project Number	: N/A	SUPPORT/ENG. SHOULD FOLLOW UP WITH CUSTOMER.	
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: I		
Previous Run	: 29920	Material	: N/A		
Written By	:	Due Date	: 4/6/2007	Qty:	1 Um: Each
Checked & Approved By	: <u>07.03.28</u>				
Comment	Est Rev: I Revised as per Rev I 05-12-07 JLM Est Rev: J reformat 06.04.04 EC Est Rev: K 07-03-20 As per DSI9361 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD206-540-013 CHG004

06.05

07.03.29

2.0	31455A	206B BASKET LID - UNDER REVIEW
-----	--------	--------------------------------



Comment: Sub-Component 206B BASKET LID

D2330-043 B 31455A

3.0	31455B	206B BASKET BASE - UNDER REVIEW
-----	--------	---------------------------------



Comment: Sub-Component 206B BASKET BASE

D2330-041 B 31455B

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y 030547

MP 07-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206B UTILITY BASKET

Job Number: 31455

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER B26664 -

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B30383 -

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B28363 -

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B29536 -

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4. D2931 Bumper B21139 -

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet M101519 -

mf 07-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206B UTILITY BASKET

Job Number: 31455

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt m10240 -

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt m101938 -

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt m101884 -

15.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Dart Logo label large

Batch: B22553 -

16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt m100771 -

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt m102140 -

mF 07-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 31455

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: ~~2.0~~ 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416 Washer m102929 -

(PTO)

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer m102519 -

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer m103344 -

21.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer m103492 -

22.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) m102658 -

23.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) m103914 -

mf

07-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-04-16	18.1	AN960JD416L Qty 2 batch: B3154	mf	07-04-16			
		Permanent change to estimate: Dwg				07-04-16	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206B UTILITY BASKET

Job Number: 31455

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

D2258170

Placard - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2258-170 Placard B16266 -

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M102535 - MF 07-04-16

26.0

D33963

Inventory



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Batch: B24583 -

07-04-17

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

MF 07-04-16

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-16 (1)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

30.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2249-041 Bracket

B23776 (1x) ✓

B31031 (1x) ✓

07-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 31455

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

4 D2022-101 Spacer

B26664 ✓

32.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2012-107 Clevis

B29883 ✓

33.0

D2259

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

B10671 ✓

34.0

D2525

Spacer Kit



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

B27554 ✓

35.0

D2526

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing

B23139 ✓

36.0

D2748

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis

B23416 ✓

37.0

D27491

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-1 Strut

B11012 ✓

*[Signature]*  
3/26/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 31455

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

D27493

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-3 Strut

B23424 ✓

39.0

D2814

Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2814 Strut

B23425 ✓

40.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

M102029 ✓

41.0

AN412

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12 Bolt

M7158 ✓

42.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

M10085-7 ✓

43.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

M102140 ✓

*[Signature]*  
3/26/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 3/26/2007 3:04:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 31455

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

*M11695* ✓

45.0

AN960JD416

Washer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

19 AN960JD416 Washer

*M1102929* ✓

46.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

*M1102519* ✓

47.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN970-4 Washer

*M1103344* ✓

48.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4)

*M1103914* ✓

49.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5 Nut

*M1102536* ✓

*CP 3/26/07 170*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 07/04/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 3/26/2007 3:04:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 31455

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

50.0

MS27039411

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 MS27039-4-11 Screw

M13355 ✓

51.0

AN46

Bolts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN4-6 Bolt

~~M10275~~ M13437 ✓

52.0

AN3204

Nut -



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN320-4 Nut

M17195 ✓

53.0

AN38022

Cotter Pins



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN380-2-2 Cotter pin

M16895 ✓

CP 04/04/17

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CC 7/4/17 (1)

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-013

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

H

PO 7/4/17 (1)

56.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ED 07/04/18 (1)

Job Completion



U Hook 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

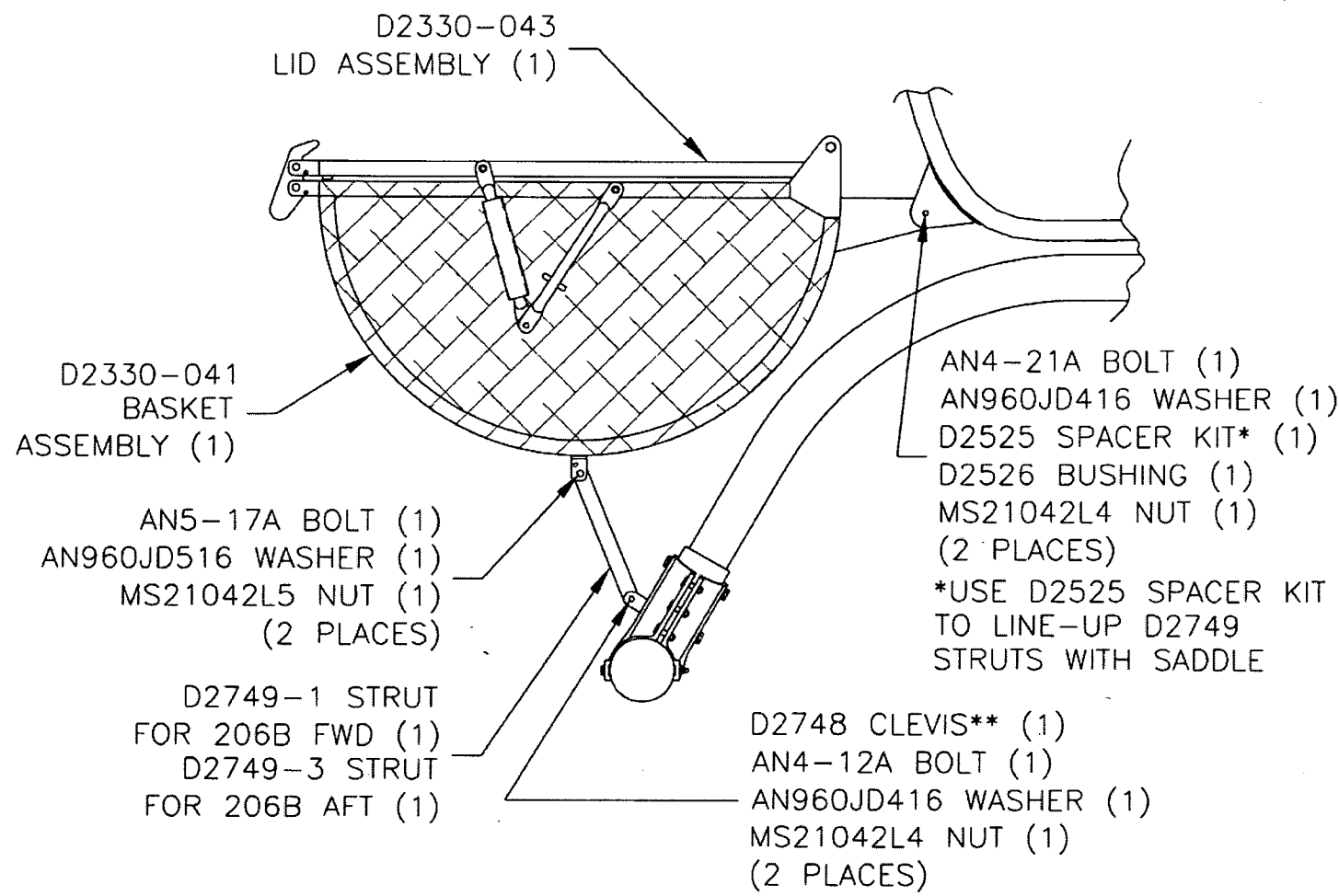
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	KE	DRAWN BY	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D206-540
DATE	05.11.10	TITLE	UTILITY BASKET INSTALLATION	SHEET 6 OF 8
		SCALE	NTS	REV. 1



\*\*NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748  
CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

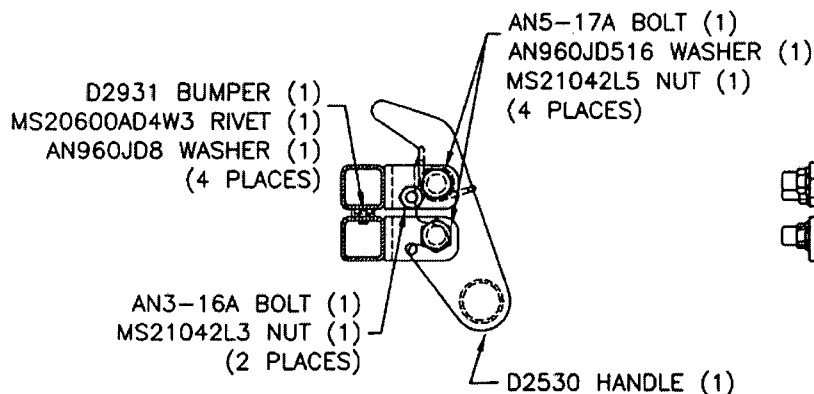
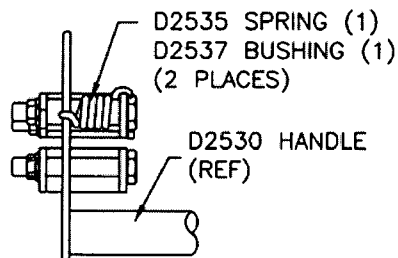
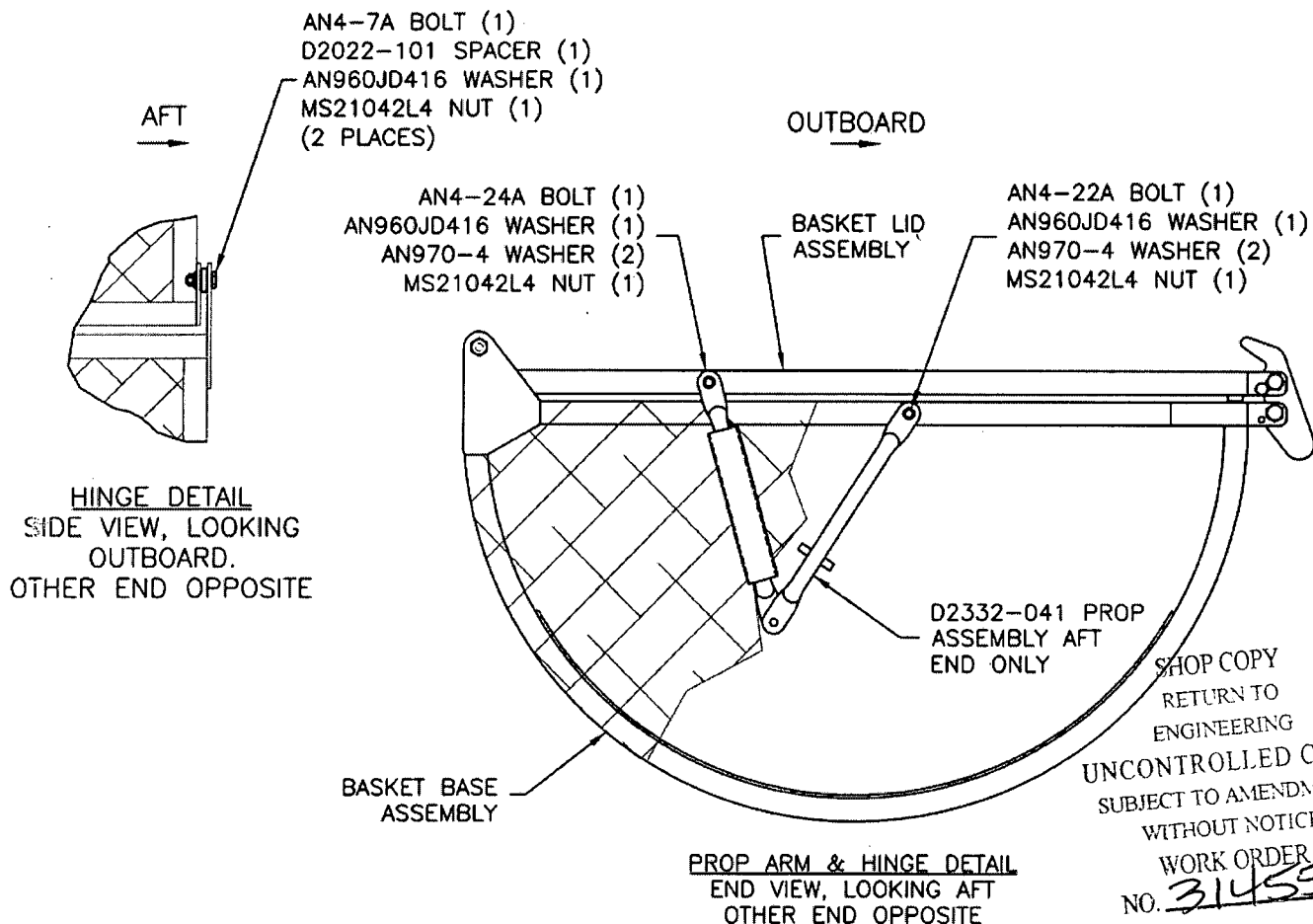
SECTION A-A AND B-B  
D206-540-013 (206 A/B) ONLY

NO. 31455  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

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**DART**

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-540	REV. 1 SHEET 8 OF 8
DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS

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DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9361	REV. A SHEET 1 OF 1
DATE 07.03.15		TITLE UTILITY BASKET SPACER	SCALE NTS
A	07.03.15	NEW ISSUE	

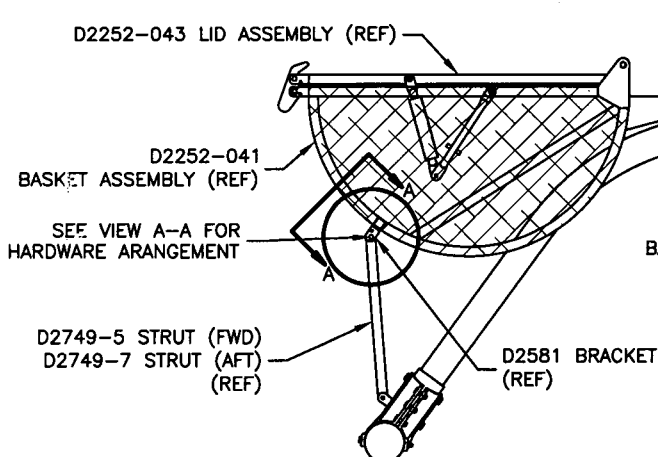
## DART SERVICE INSTRUCTION

TO AMEND DART INSTALLATION DRAWING D206-540 REV. I  
REF. CANADIAN STC: SH94-5  
REF. FAA STC: SR00386NY

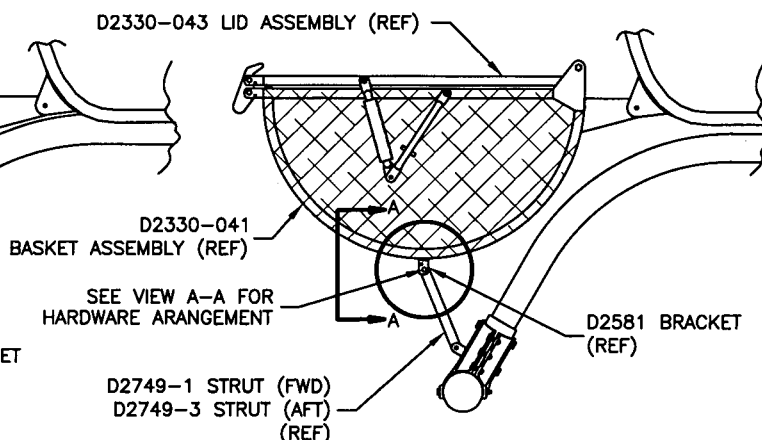
The following parts will be **added** to the Parts List on page 1 of Installation Drawing D206-540.

Qty - 011	Qty - 013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
4	4	D3396-3	SPACER

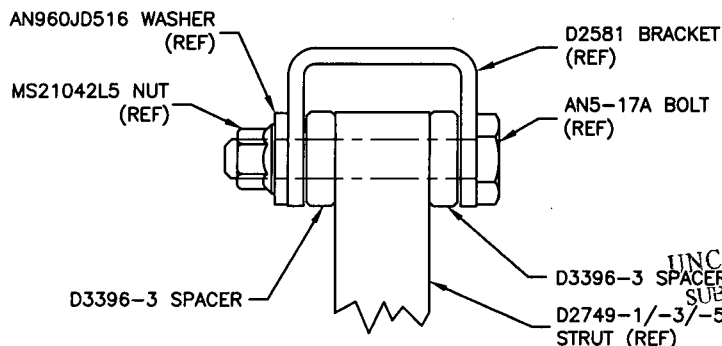
Install qty(2) D3396-3 Spacers per strut at the location shown in **Figure 1** (for D206-540-011 kit) and **Figure 2** (for D206-540-013 kit). Install hardware per View A-A



**FIGURE 1 - D206-540-011  
INSTALLATION**



**FIGURE 2 - D206-540-013  
INSTALLATION**



**VIEW A-A - HARDWARE  
ARRANGEMENT (TYP)**

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WORK ORDER  
NO. 31455

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 07.03.15  
CERT. NO.: SH94-5  
ISSUE NO.: 4

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Date: Monday, 3/26/2007 3:04:42 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 31455  
 Estimate Number : 11282  
 P.O. Number :  
 This Issue : 3/26/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : LARGE FAB ASSY  
 Previous Run : 29920

Drawing Name : 206B UTILITY BASKET  
 Part Number : D206540013  
 Drawing Number : D206-540 REV I  
 Project Number : N/A  
 Drawing Revision : I  
 Material :  
 Due Date : 4/6/2007

AS PER DISCUSSION  
 WITH BILL B., TECH.  
 SUPPORT/ENG. SHOULD  
 FOLLOW UP WITH  
 CUSTOMER.

Qty: 1 Um: Each

Written By :  
 Checked & Approved By : 07.03.28  
 Comment : Est Rev: I Revised as per Rev I 05-12-07 JLM  
 Est Rev: J reformat 06.04.04 EC  
 Est Rev: K 07-03-20 As per DS19361 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-540-013 CHG004

07.03.28

2.0 31455A 206B BASKET LID - UNDER REVIEW



Comment: Sub-Component 206B BASKET LID  
 D2330-043 B

3.0 31455B 206B BASKET BASE - UNDER REVIEW



Comment: Sub-Component 206B BASKET BASE  
 D2330-041 B

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick: Assembly Kit

5.0 D2332041 Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Pick: Assembly Kit  
 Qty Part Number Description Batch  
 1 D2332-041 Prop Ass'y

REFERENCE ONLY

Date: Monday, 3/26/2007 3:05:00 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B BASKET LID - <del>UNDER REVIEW</del>
Job Number	: 31455A		
Estimate Number	: 11280		
P.O. Number	: <i>N/A</i>	Part Number	: D2330043
This Issue	: 3/26/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2330 <del>UNDER REVIEW</del>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 29920A	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/6/2007
Checked & Approved By	: <i>[Signature]</i> 07.03.28	Qty:	1 Um: Each
Comment	: Est Rev: 02.09.04 M304EX0.75-16F was M750-16FXS-S/SK		

*As discussed with Bill B, Proceed. (see note on #31455 J/W) 07.03.27*

## Additional Product



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 23.3625 f(s)/Unit Total : 23.3625 f(s)  
3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: *M103987*

*Ppl 07.04.11*

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

*Ppl 07.04.11*

3.0	D22321	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pick:

Qty Part Number	Description	Batch
2 D2232-1	HINGE	<i>B29535</i>

*Ppl 07.04.11*

4.0	D2329	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick:

Qty Part Number	Description	Batch
1 D2329	Label Plate	<i>B29936</i>

*Ppl 07.04.11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 31455A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23271

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-1 Bushing B28334

Cpl 07-04-11

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Chancel B30552

Cpl 07-04-11

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number Description Batch

18 sf M304EX0.75-16F Expanded Metal M1004001

Cpl 07-04-11

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: M101972

Cpl 07-04-11

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-04-12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-04-12

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

HF 07-04-13

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   P   Date: 27/04/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:05:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 31455A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-04-16

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GIA

MF 07-04-16

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 07-04-17

Job Completion



MF 07-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

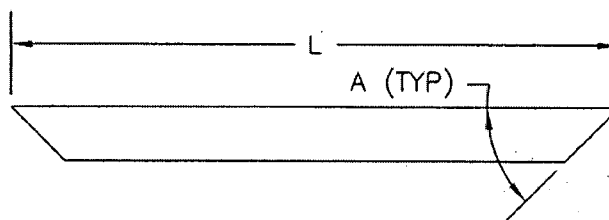
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2330	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

## NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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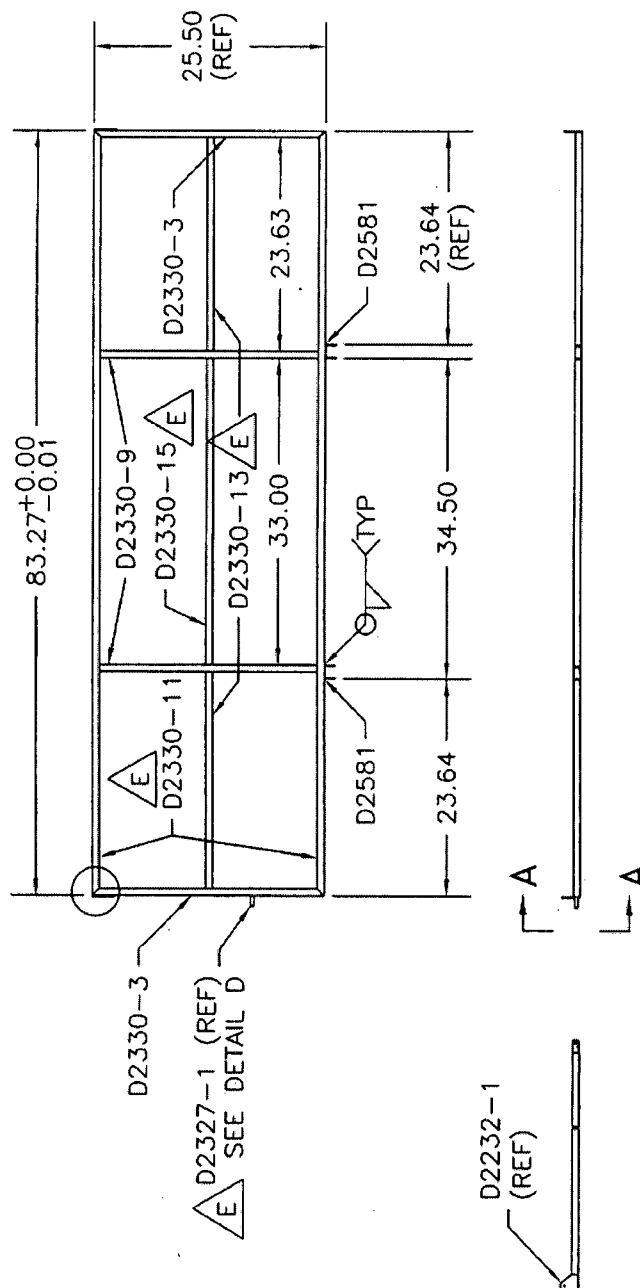
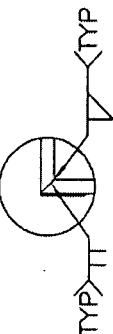
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS

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AS SHOWN



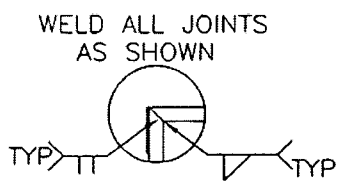
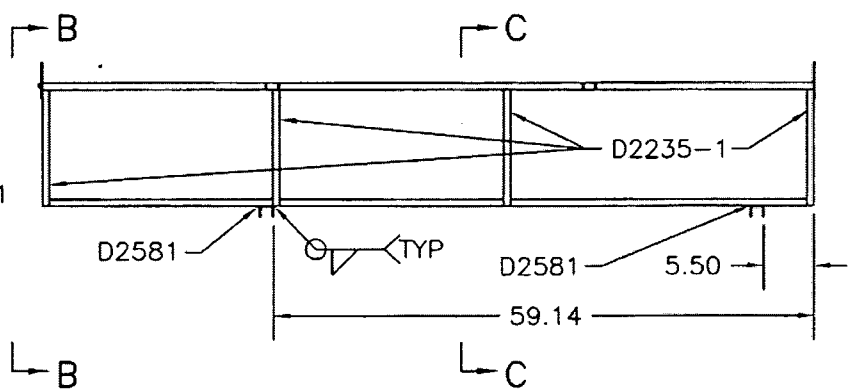
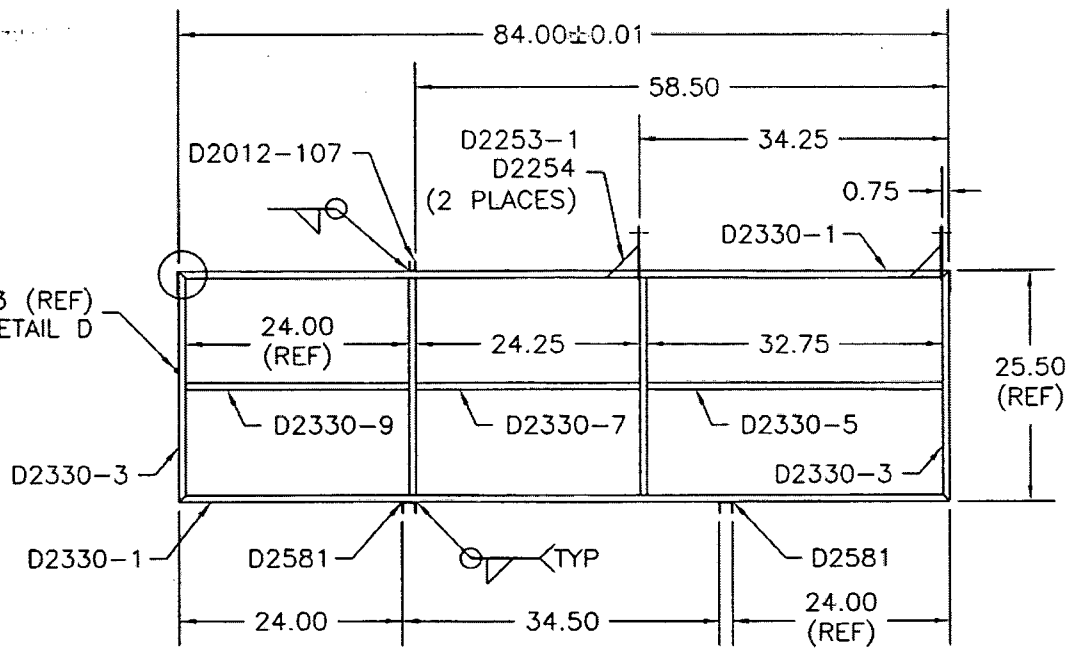
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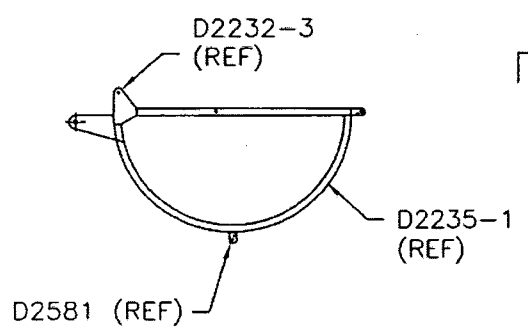
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		TITLE	BASKET ASSEMBLY (206B)	SHEET 3 OF 5
				SCALE
				NTS



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05.11.26

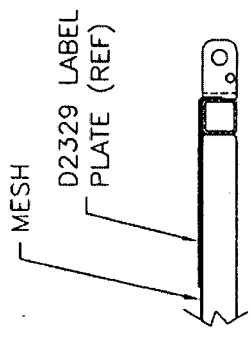
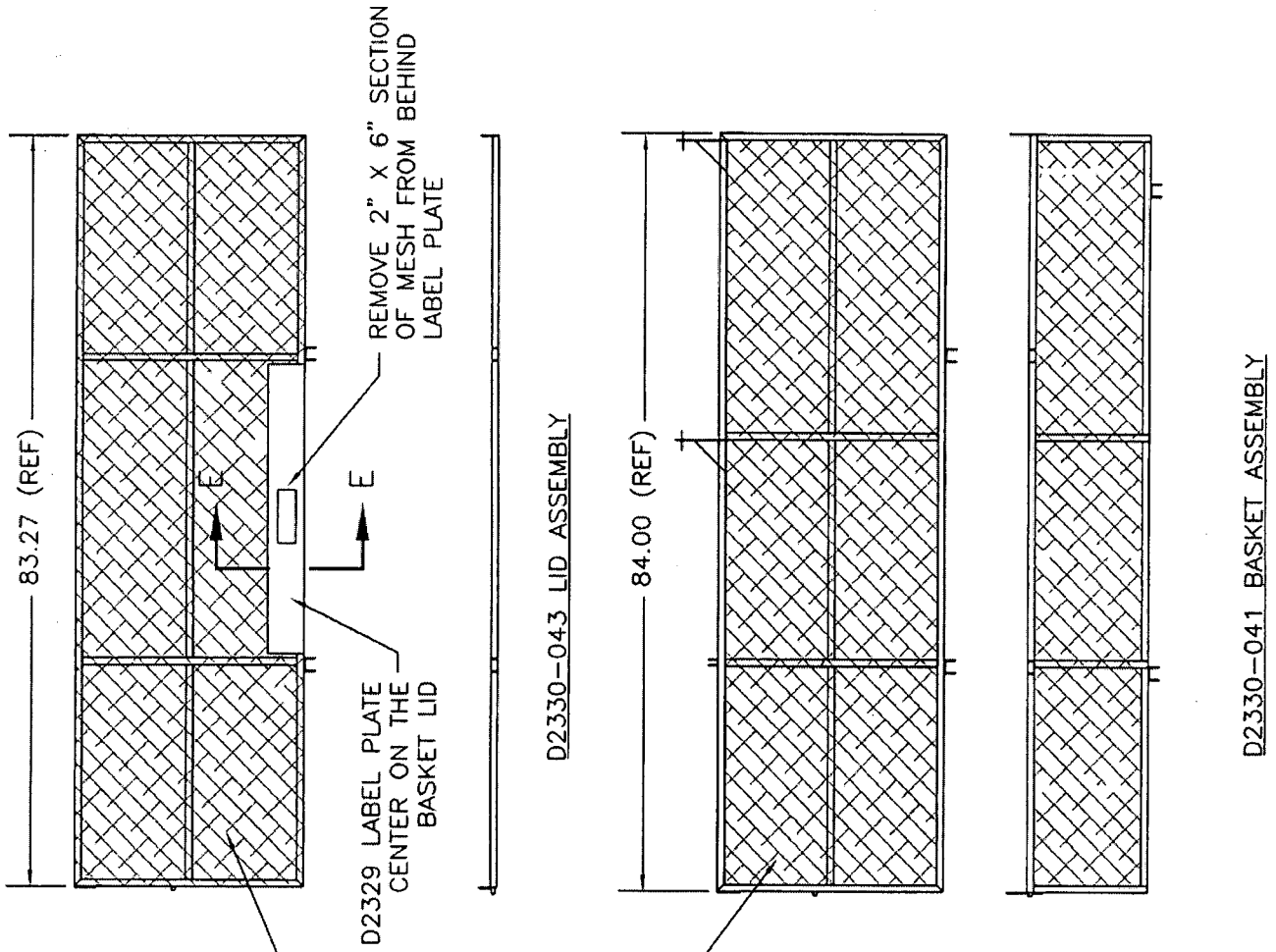


D2330-041 BASKET FRAME

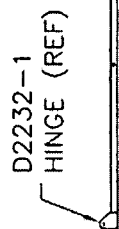
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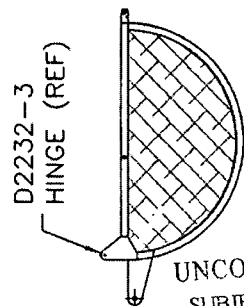
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



SECTION E-E



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME



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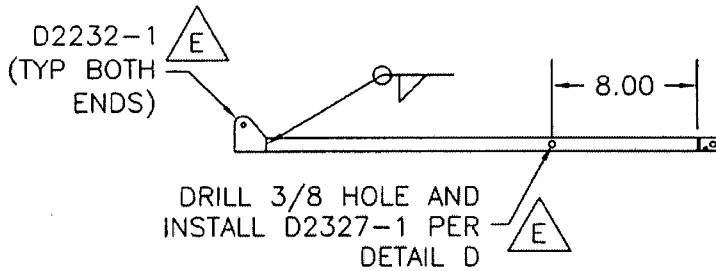
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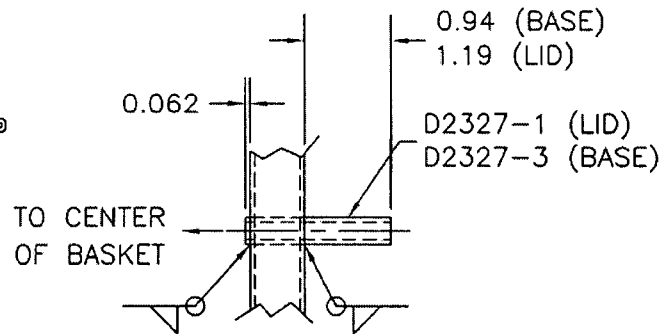




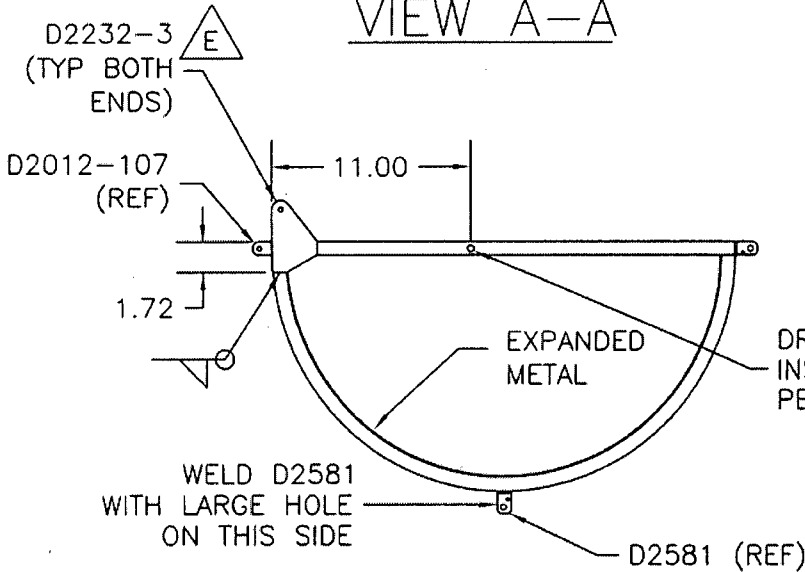
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CHECKED 	APPROVED 	DRAWING NO. D2330	REV. E SHEET 5 OF 5
DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



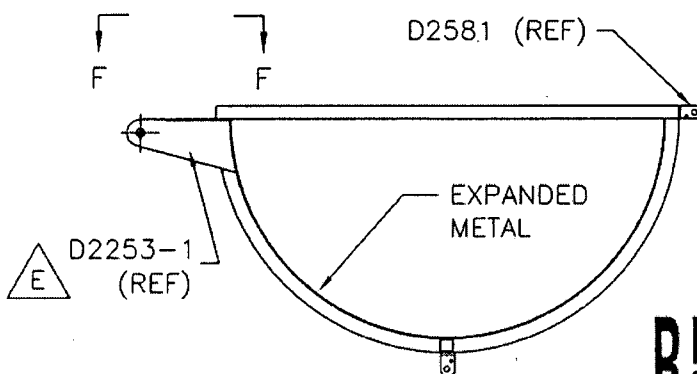
VIEW A-A



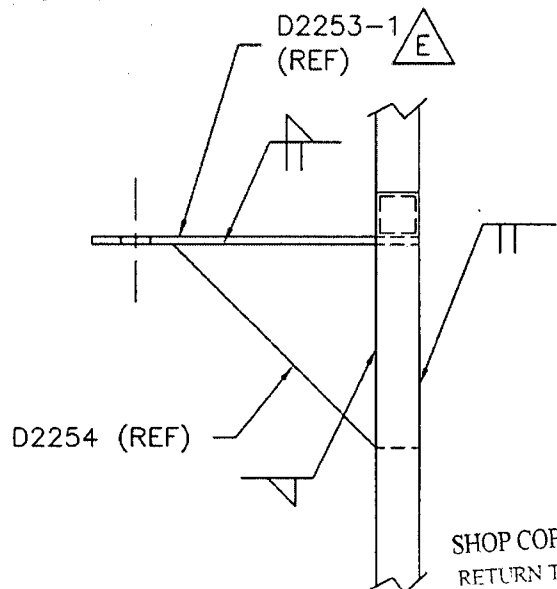
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VIEW B-B



VIEW C-C



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Date: Monday, 3/26/2007 3:07:30 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B BASKET BASE - <del>UNDER REVIEW</del>
Job Number	: 31455B		
Estimate Number	: 11276		
P.O. Number	: <i>N/A</i>	Part Number	: D2330041
This Issue	: 3/26/2007	S.O. No. :	<i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2330 <del>UNDER REVIEW</del>
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 29920B	Drawing Revision	: E
Written By	: <i>[Signature]</i>	Material	: <i>N/A</i>
Checked & Approved By	: <i>[Signature]</i>	Due Date	: 4/6/2007
Comment	: Est Rev: H 02.09.04 M304EX0.75-16F was M750-16FXS-S/SK		

Qty: 1 Um: Each

*Discussed with Bill B., proceed (Gusset on #31455 2/2) 4-07-03-24*

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
4	D3166-1	Hoop	<i>B31491</i>

*CPL 07.04.11*

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 25.3019 f(s)/Unit Total: 25.3019 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: *M103987**CPL 07.04.11*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 4 D2235-1 From D3166-1

2- Cut D2330-1-3-5-7-9 as per Dwg D2330

3-Drill hole in D2330-3 as per Dwg D2330

4-Deburr

*CPL 07.04.11*

4.0	D22531	Lug
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

\* Gusset  
 Batch: *B12413 → 1 B27553 → 1* ✓

*CPL 07.04.11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 3/26/2007 3:07:30 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 31455B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2012-107 Clevis

B29883

*Ppl 07-04-11*

6.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing

B28597

*Ppl 07-04-11*

7.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chancel

B30003

*Ppl 07-04-11*

8.0

D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug

B23421

*Ppl 07-04-11*

9.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE

B29132

*Ppl 07-04-11*

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal

H11004001

*Ppl 07-04-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:07:30 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 31455B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

✓ 1-Weld as per Dwg D2330 using Welding Table and corner JigDebur as required

A/R SS ROD

Batch: M101972

*CP 07-04-11*

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-04-12*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PD 07-04-12*

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*GL 07-04-13*

*(1)*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*MF 07-04-16*

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*MF 07-04-16*

*(1)*

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*PD 07-04-17*

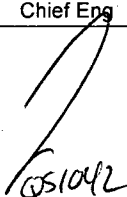
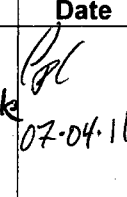
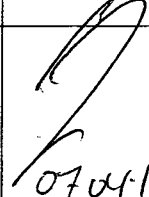
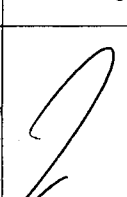
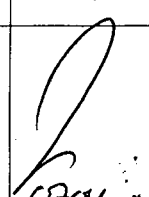
Job Completion



*U 07-04-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/04/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/04	11.0	Welded one D2327-3 on each side of basket. Need only one D2327-3	 QS1042	Cut off one A2327-3 as per dwg and plug hole <del>weld</del> with weld and grind Flush	 07-04-11	 07-04-16	 QS1042	 07-04-04

NOTE: Date & initial all entries

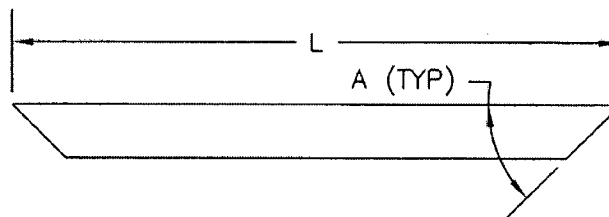
**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2330	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B) SCALE NTS	
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

**NOTES:**

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.075W.0.60)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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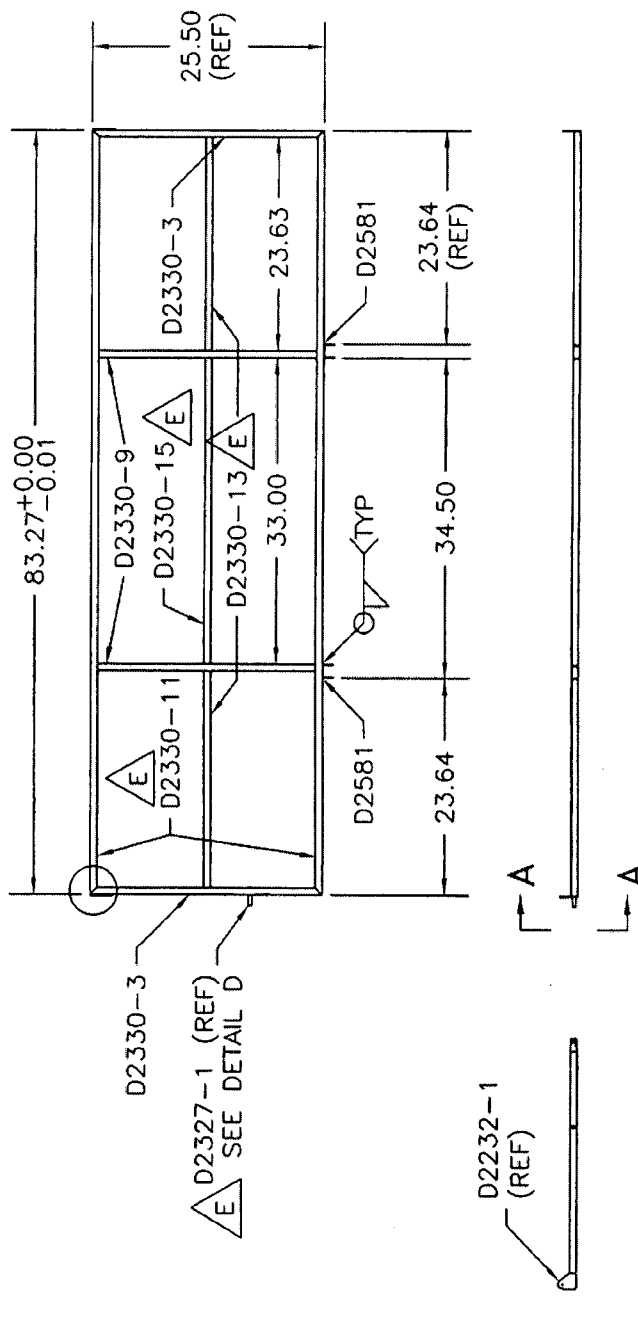
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS

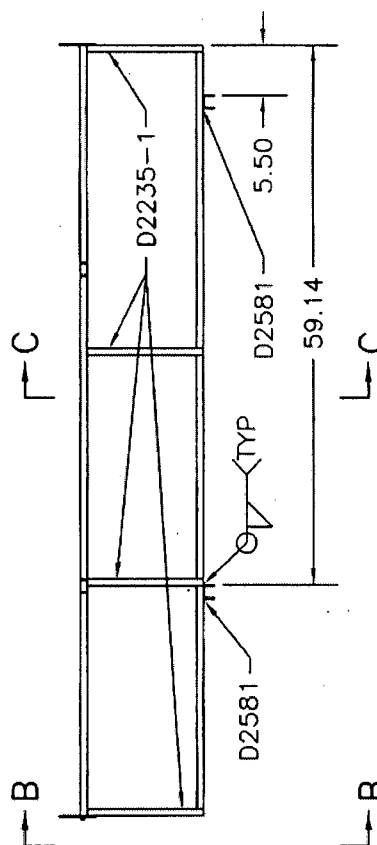
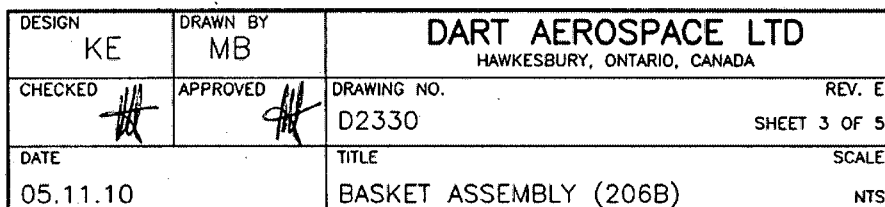
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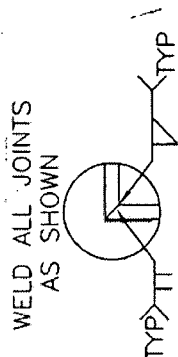
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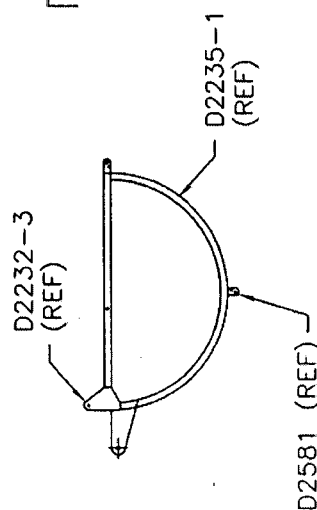


D2330-041 BASKET FRAME



D2327-3 (REF)  
SEE DETAIL D

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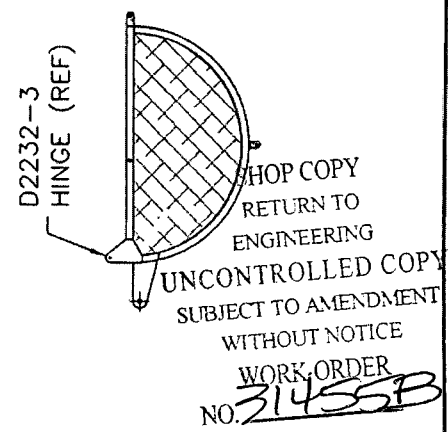
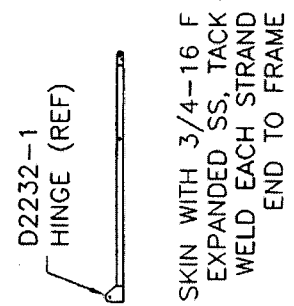
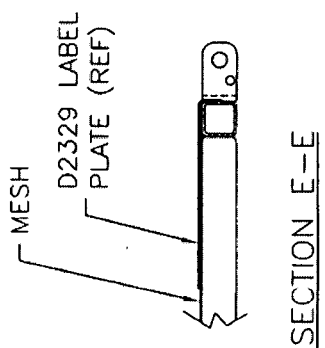
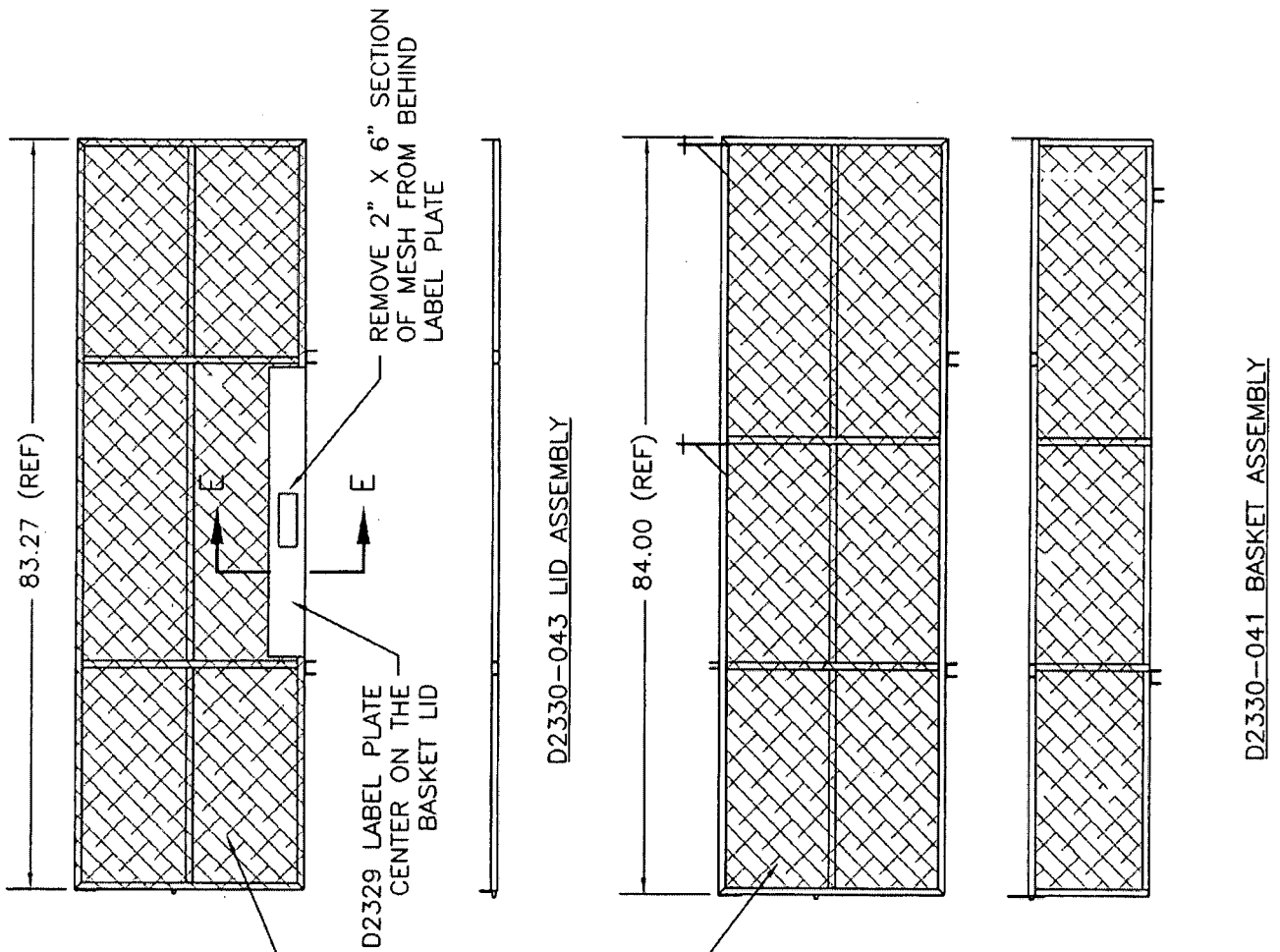
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



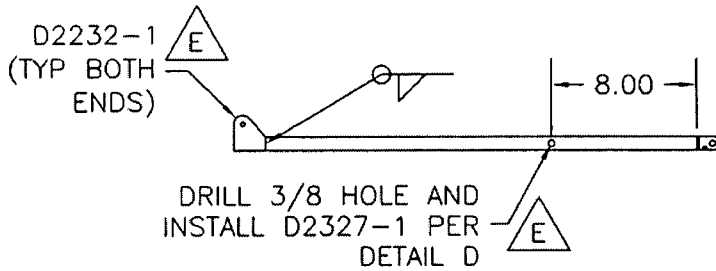
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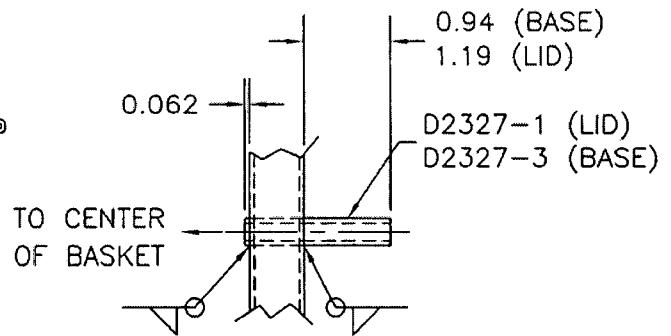
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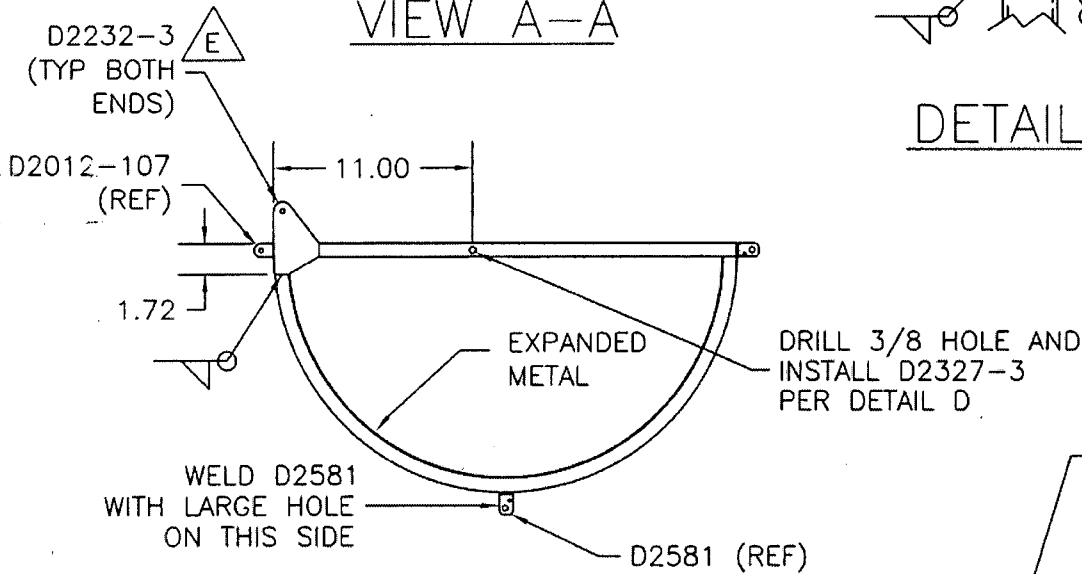
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DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS



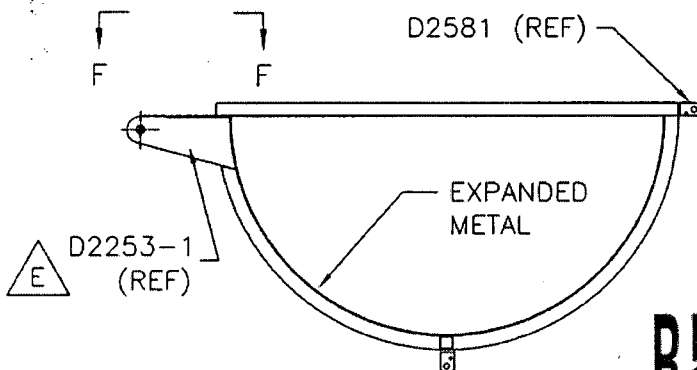
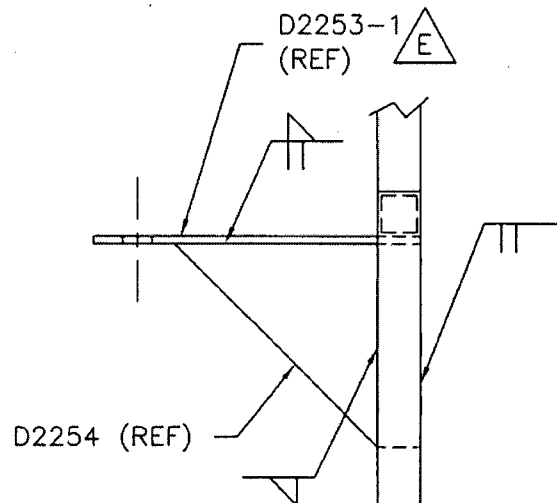
VIEW A-A



DETAIL D



VIEW B-B



VIEW C-C

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